

**Work Order ID 70600**

Monday, June 13, 2011 10:57:52 AM



Page 1

Item ID: D412-698-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Handle

Start Date: 6/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:                     Date: 11-06-12Tooling:                     Date:                     

Run Start

QC:                     Date:                     SPC (Y/N):                     Date:                     

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D412-698-013CHG001

8/6/12JB for BG 11-6-24

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

JB 11/06/22

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/6/12(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70600**

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Item ID: D412-698-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Handle

Start Date: 6/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-013 Location: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Run/8/29 (2)

11/6/27

MF  
11-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 13, 2011 10:58:05 AM

Page 1

Work Order ID: 70600

Parent Item: D412-698-013

Parent Item Name: Door Handle

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: C Removed Manufacturing 05-11-06 JLM  
IPP Rev: D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD416L Washer	NAS1149D0416J	Purchased	No				Each	33.0000	16	11651344 JB			
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Location Loc Qty Loc Code

FP-B	33	
110153	33	
	Each	26.0000

D3203-1 Handle		Manufactured	No				Each	26.0000	8	110153x12 JB			
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Location Loc Qty Loc Code

ST240	26	
65003	6	
69020	20	
	Each	6.0000

D3220-041 Doubler Assembly		Manufactured	No				Each	6.0000	2	65003x2 JB			
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Location Loc Qty Loc Code

ST177	6	
68789	6	
	Each	5.0000

D3220-042 Doubler Assembly		Manufactured	No				Each	5.0000	2	68789 JB			
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Location Loc Qty Loc Code

ST177	5	
65002	1	
68790	4	

65002x1  
68790x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 13, 2011 10:58:05 AM

Page 2

Work Order ID: 70600

Parent Item: D412-698-013

Parent Item Name: Door Handle

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

D3220-3 Manufactured No

Each 19.0000

4 ✓



5+2 Doubler

Location

Loc Qty

Loc Code

ST180a

19

65081

6

69038

13

MS21042L4 Purchased No

Each 5,203.0000

16 ✓



5+2 Nut

Location

Loc Qty

Loc Code

ST300

5203

117441

2903

117601

800

117885

1500

MS24694-S98 Purchased No

Each 105.0000

32 ✓



5+2 Screw

Location

Loc Qty

Loc Code

ST289A

105

116582

105

116582

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



## REFERENCE ONLY

**6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Date: 08.05.01